

Slp 30/04

Work Order ID 116261 -1

116261

April-09-14 1:40:56 PM

D3910-5
B116261

Item ID: D3910-5 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Crosstube Lug
Start Date: 4/09/14 Start Qty: 60.00 *60* Cust Item ID:
Required Date: 4/18/14 Req'd Qty: 60.00 *60* Customer:
Reference:

Approvals: Process Plan: u Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	D								

110 Outsource process - Machining 0.00
110 HAAS CNC VERTICAL MACHINING #1

Outsource5 Memo 0.00
Outsource process - Machining Issue P/O to ATG: 23784
MANUFACTURE AS PER DWG
C of C is required

CX 14/04/14 60

120 Receive & Inspect for Damage & Mat'l Certs 0.00

120 Packaging 0.00
Packaging Memo Ensure C of C is attach

POSITIVE RECALL

EFFECTIVE 14/4/29 AUTH u

RELEASED u DATE 14.04.29

working on certs & packing slip - please proceed under positive recall 14.04.29

130 QC6- Inspect dimensions to drawing 0.00

130 QC 0.00
Quality Control Memo

14/4/29

70

DAS 10 9-89 13B

demoml conversion
QC 7

70 ~~14.4.29~~ 14.4.29

70 14-4-29

Work Order ID 116261

116261

Page 2

April-09-14 1:40:56 PM

Item ID: D3910-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cresscube Lug
 Start Date: 4/09/14 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 4/18/14 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
10
9-89

135
136

gross white powder coat
 M108007
 START: 1:55
 OVEN: T: 300°
 Finish: 2:25

QC 3



DAS
27
14/4/29

76
ca

MLJ 14-05-01

70 14-11-29

14/4/30

(70)

DAS
34

Picklist Print

April-09-14 1:40:56 PM

Page 1

Work Order ID: 116261

116261

Parent Item: D3910-5

D3910-5

Parent Item Name: Crosstube Lug

Start Date: 4/09/14

Required Date: 4/18/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
13.09.26 AS PER REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423

Manufactured

No

f

202.6668

8

D2423

Lug Extrusion

MF 4-11-30

Location

Loc Qty

Loc Code

HALL

202.666848

202.666848

105422

D3910-5P

Purchased

No

Each

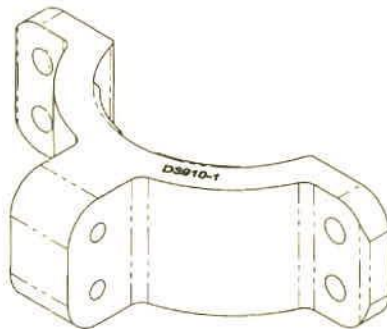
0.0000

60

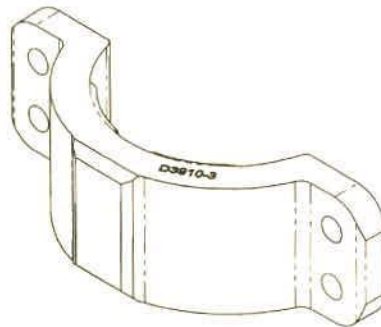
D3910-5P

Crosstube Lug

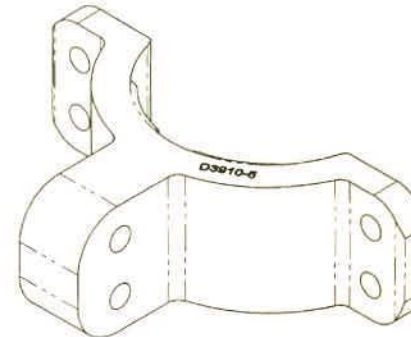
P44/2/25 (20)



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG

W/O 116261

RELEASED
2013-09-23

NOTES:

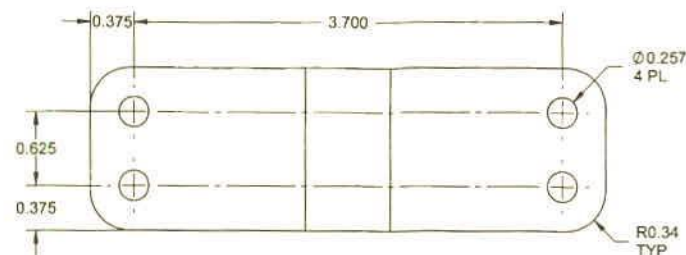
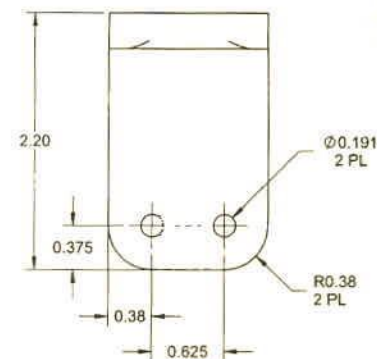
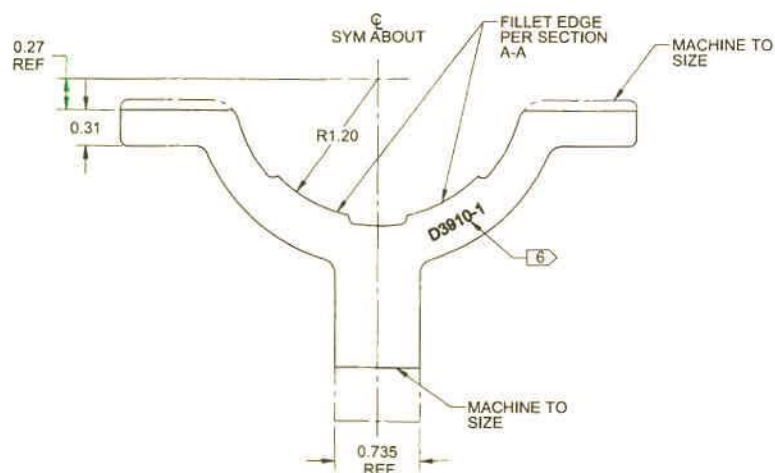
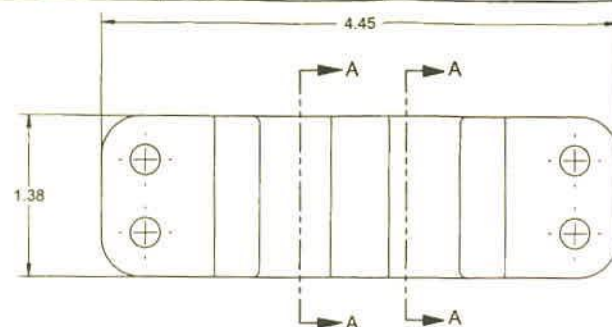
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs

D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE REASON: EASE OF INSTALLATION	AJS	13.08.14
C	ADD -5	AJS	13.08.08
B	3/8" 257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0 34 FILLET WAS R0.50 (A3-2) & (A3-3); REASON: SEE TR-0350-007.2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	13.08.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

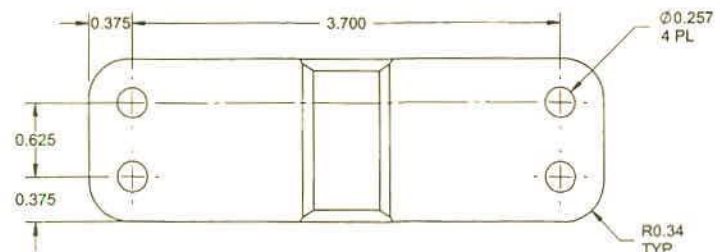
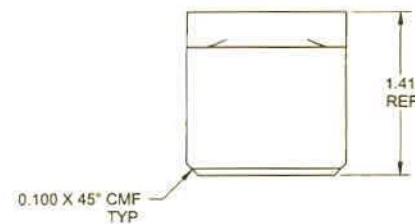
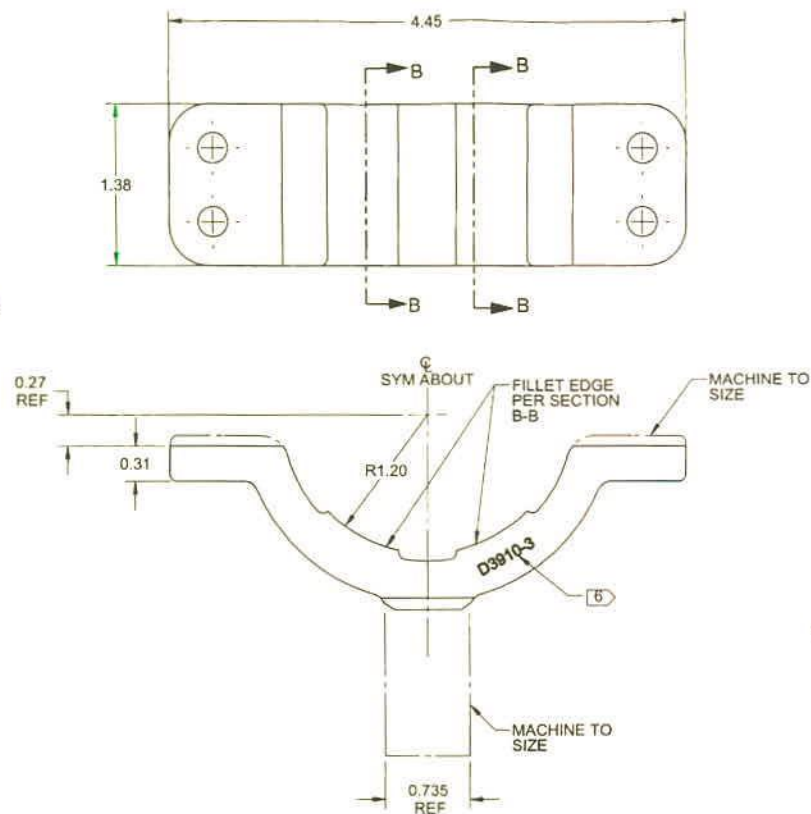
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B



D3910-3 X-TUBE LUG

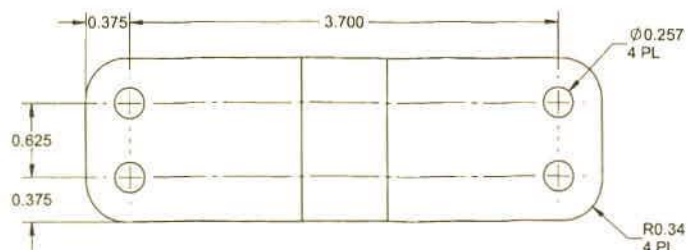
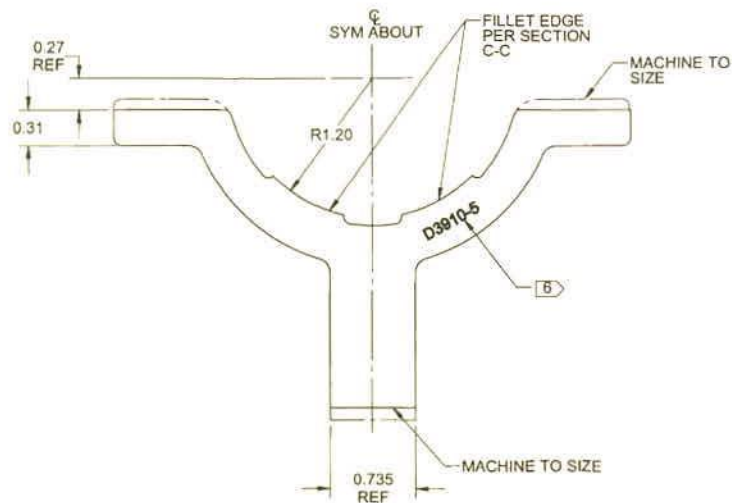
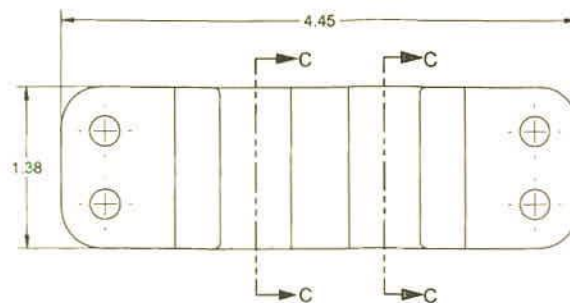
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MP

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MFG. APPR.	AP	D3910	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	X-TUBE LUG (350)	NTS
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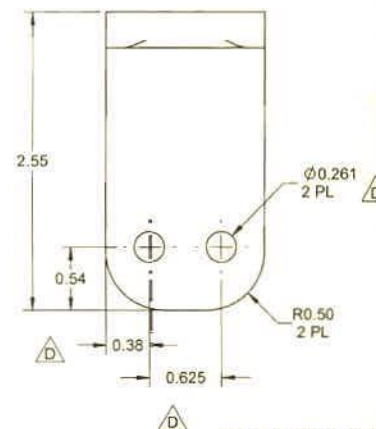
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG



RELEASED
2013-09-23

DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	AJS	DRAWING NO	REV. D
MFG. APPR.	21	D3910	SHEET 4 OF 4
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DE APPR.	140	X-TUBE LUG (350)	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23784

Purchase Order Date 4/14/2014
PO Print Date 4/14/2014

Page Number 1 of 2

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
4/14/14

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	CAD
Ship Via:	Dart Truck	FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2731-3P	Lug	4/28/2014 Yes 4/28/2014		50.00 Each	\$16.95	\$847.5

MACHINE AS PER DWG D2731 REV. C
B115885

Line Total: \$847.5

2	D3910-5P	Crosstube Lug	4/28/2014 Yes 4/28/2014		60.00 Each	\$31.55	\$1,893.
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MACHINE AS PER DWG D3910 REV. D
B116261

Line Total: \$1,893

Note:

4/14/2014



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

70

D3910-5

Crosstube Lug

PO 23784

MATERIAL: supplied by DART B105422

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over a horizontal line.

Jan Norris

Vankleek Hill, April 28, 2014



METAL TECHNOLOGY INC.

20 Terry Fox Drive
Vankeek Hill, Ontario K0B 1R0, Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19977

Date:

Apr 28, 2014

Page:

1

Sold to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 23784	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Apr 28, 2014

D2731-3 Mounting Lug
as per drawing D2731 REV.C

Each 50

D3910-5P Crosstube Lug
as per drawing D3910 REV.D

Each 60

70

DAS
27
9-09

4/4/09

2
4/29/09

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by _____

Thank you for your order!